

Date: Monday, 6/12/2006 2:25:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER ASSEMBLY, RH
Job Number	: 27484	Part Number	: D3163042
Estimate Number	: 10918	Drawing Number	: D3163 REV 0
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/12/2006 S.O. No. N/A	Drawing Revision	: 0 D 060705
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/19/2006
Previous Run	: 25626	Qty:	2 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: [Signature] 06.06.12		
Comment	: Est. A 05.10.05 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :												
1.0	D31631	Plate												
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Plate Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3163-12</td> <td>Plate</td> <td>B27381</td> </tr> </tbody> </table> FF 06.06.12 2			Qty	Part Number	Description	Batch	1	D3163-12	Plate	B27381				
Qty	Part Number	Description	Batch											
1	D3163-12	Plate	B27381											
2.0	D31633	Plate												
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Plate Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3163-3</td> <td>Plate</td> <td>B27381</td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Sikaflex 241/291</td> <td>11.10.193</td> </tr> </tbody> </table> Expiry Date: 11-2006 Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up FF 06.06.12 2			Qty	Part Number	Description	Batch	1	D3163-3	Plate	B27381	A/R	N/A	Sikaflex 241/291	11.10.193
Qty	Part Number	Description	Batch											
1	D3163-3	Plate	B27381											
A/R	N/A	Sikaflex 241/291	11.10.193											
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1												
Comment: SMALL & MEDIUM FAB RESOURCE 1 Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up FF 06.06.12 2														
4.0	QC5	INSPECT WORK TO CURRENT STEP												
Comment: INSPECT WORK TO CURRENT STEP Inspect bonding of D3163-1/-3 06.06.14 (2) N/A														

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Part Number: D3163042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m. 06/07/18
DL 06/06/21

(2)

(PTO)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06 07 18

(2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

C'sink D3163-3 as per Dwg D3163.

Touch up c'sink holes with alodine.

FF 06.07-06

8.0

MS20426AD3-4

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

RIVET

Pick:

Qty

Part Number

Description

Batch

2

MS20426AD3-4

Rivet

~~M19099~~ M4179

FF 06.08.09

9.0

MS21059L08

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

1

MS21059L08

Nut Plate

M12706

Assemble nut plate as per Dwg D3163 D3163-3

Identify as D3163-042

FF 06.08.09

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.08.11

FF 06.08.09

Pick 4 MS20426AD3-4 Rivet

Batch: ~~M19099~~

MS20426AD4-4 Rivet

M1021

ACCEPTABLE DEVIATION

06.08.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-06	8	- 5 rivet required for nut plate ASS'y. Permanent change <i>[Signature]</i>	PH 06.08.08 per QSS 042		2	PH 06.08.08 per QSS 042	<i>[Signature]</i> 06-08-08

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-05	50	S.KAflex welded in the overcausing the 2 plates to shift, misaligning the holes	<i>[Signature]</i> QSS 042	Re-work parts to the new Dwg: 03163 Rev.D Starting at step 5. Remove S.KAflex, and Alodine (as per QSS 042) as necessary.	FF 06.07.10	<i>[Signature]</i> 06-08-11	<i>[Signature]</i> QSS 042	<i>[Signature]</i> 06-07-05
06-08-11	9	Hole size too large. → .128 Human error.	<i>[Signature]</i> QSS 042 06.08.16	See steps, use larger rivet as shown. Acceptable this time only. Verify bit size before using.	FF 06.08.09	<i>[Signature]</i> 06-08-11	<i>[Signature]</i> QSS 042 06.08.16	<i>[Signature]</i> 06-08-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/08/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27484

Part Number: D3163042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock

Location: ST132

LB

06/05/14

②

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/16

Job Completion

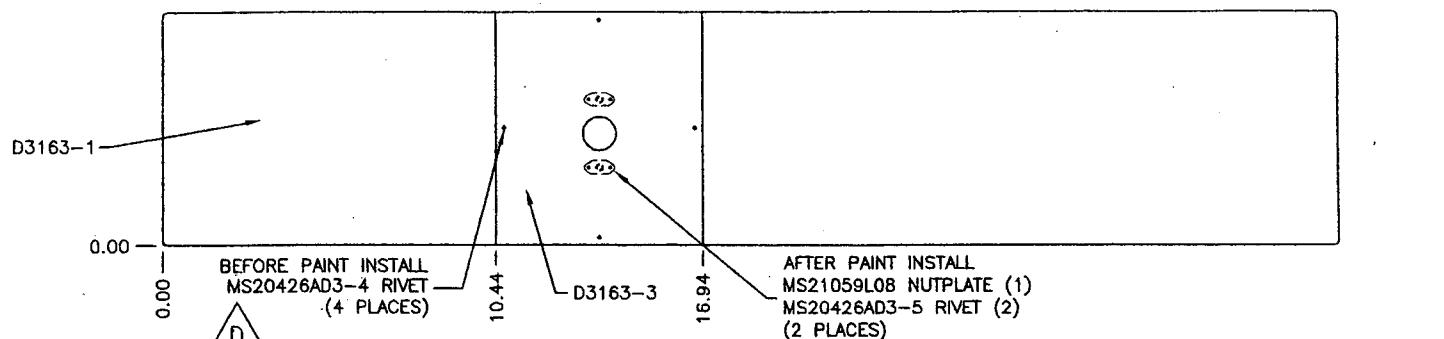


U 06-08-16

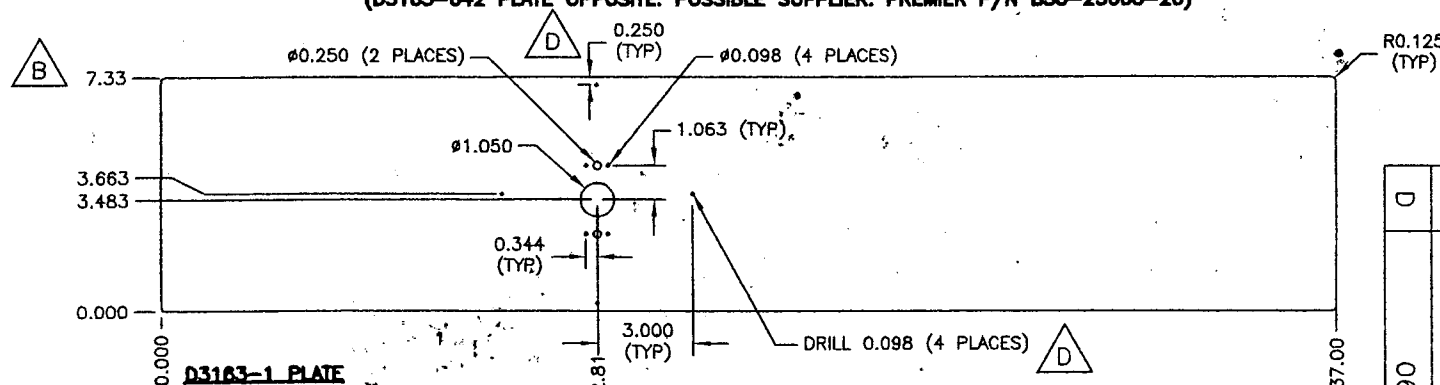


DECLASSIFIED
DATE 06-29-88

DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
CHECKED	APPROVED	DRAWING NO. D3163	SHEET 1 OF 1	
DATE 06.06.26		TITLE PLATE	SCALE 1:6	
A	02.04.26	NEW ISSUE		
B	04.10.06	7.33 WAS 7.20; REMOVE PERIMETER HOLES		
C	05.11.22	Ø1.050 WAS Ø1.000		
D	06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE		



D3183-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3183-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)



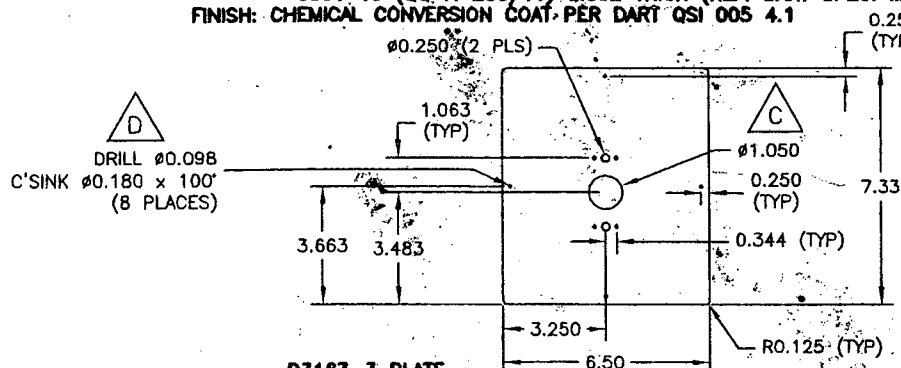
D3163-1 PLATE

(D3163-2 PLATE OPPOSITE)

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR

6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



D3183-3 PLATE

MATERIAL: 2024-T3 (QQ-A-250/4) 0.083 THICK (M2024T3S.083) OR

6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES.
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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NO. 01484

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